

*TODAY*

Date: Thursday, 18/01/2007 1:57:39 PM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LUG
<b>Job Number</b> : 30313	
<b>Estimate Number</b> : 12657	
<b>P.O. Number</b> : <i>NIA</i>	<b>Part Number</b> : D35893
<b>This Issue</b> : 18/01/2007 <b>S.O. No.</b> : <i>NIA</i>	<b>Drawing Number</b> : D3589 UNDER REVIEW
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>NIA</i> <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : U/R
<b>Previous Run</b> : <i>NIA</i>	<b>Material</b> : <i>NIA</i>
<b>Written By</b> : _____	<b>Due Date</b> : 25/01/2007
<b>Checked &amp; Approved By</b> : _____	<b>Qty</b> : <i>6</i> <b>Um</b> : Each
<b>Comment</b> : Est Rev :A New Issue 07-01-16 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 .063 Sheet
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**Comment:** Qty.: 0.0037 sf(s)/Unit Total : 0.0037 sf(s)

304/316 .16GA Sheet

Batch: *m101463*

*ml 07 01 18*

*(6)*

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3565

Dwg Rev: *U/R*

Prog Rev: *U/R*

*ml 07 01 18*

*(6)*

2-Deburr if necessary

*mlf. 07-01-18*

*(6)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*ml 07 01 18*

*(6)*

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*ml 07/01/18*

*(6)*

*(PTO)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

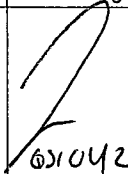


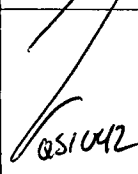

*ml 07/01/18 (6)*

*u 070619*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/18		Wrong thickness of material	 051042	- Scrap 6 parts and - replace them with the right thickness 304 S.S. 16gA	 07/01/18	 07/01/18	 051042	 07/01/18

NOTE: Date & initial all entries

Date: Thursday, 18/01/2007 1:57:39 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 30313

Part Number: D35893

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

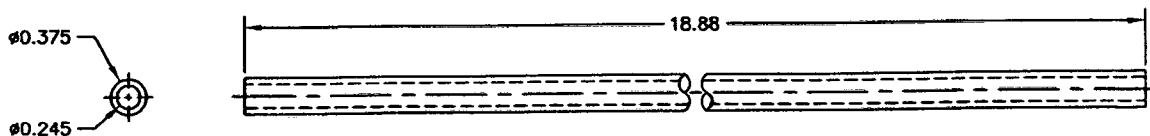
Handwritten: 07/01/19 (circled 6)

Job Completion

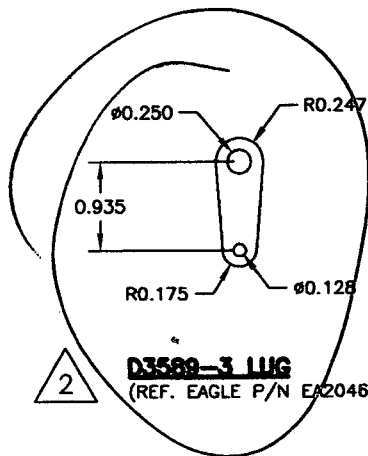


# PRELIMINARY ISSUE

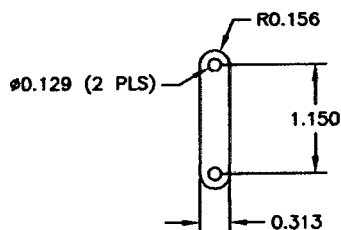
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3589	REV. A SHEET 3 OF 4
DATE 07.01.05	TITLE ARM LATCH ASSEMBLY		SCALE 1:1



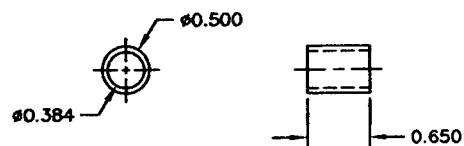
**1** D3589-1 ARM  
(REF. EAGLE P/N EA20469-29)



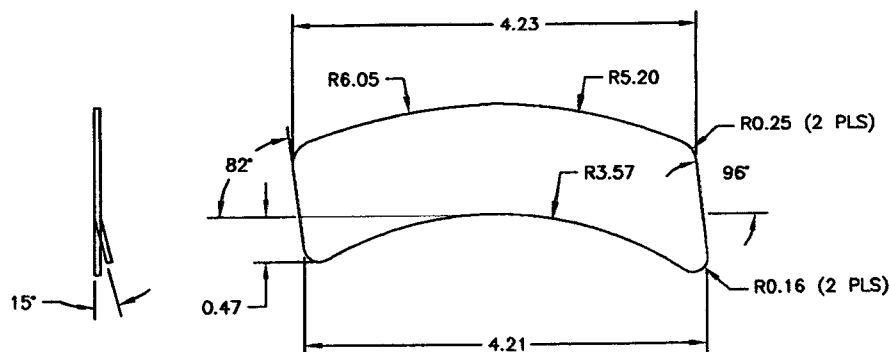
**2** D3589-3 LUG  
(REF. EAGLE P/N EA20469-22)



**2** D3589-5 LINK  
(REF. EAGLE P/N EA20469-23)



**3** D3589-7 ARM GUIDE  
(REF. EAGLE P/N EA20469-28)



**2** D3589-9 AFT DOOR PLATE FLAT PATTERN  
(MAKE FROM D3589-9F)

## NOTES:

- 1) MATERIAL: AISI 4130 STEEL TUBING  $\phi 0.375$  O.D. 0.065 WALL (REF. DART SPEC M4130N-T-0375W065)
- 2) MATERIAL: AISI 4130 SHEET 16 GAUGE (0.063) THICK PER MIL-S-18729/AMS6350/AMS6351 (REF. DART SPEC M4130N-S.063) NORMALIZED
- 3) MATERIAL: AISI 4130 STEEL TUBING  $\phi 0.500$  O.D. 0.058 WALL (REF. DART SPEC M4130N-T-0500W058)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	30313
Description: LUG	Part Number:	D3589-3
Inspection Dwg: D3589 U/R Rev: U/R		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

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## First Article

**X**

## Prototype

[illegible]

Measured by:	<i>mf. mf</i>	Audited by:	<i>JA</i>	Prototype Approval:	
Date:	<i>07/01/18</i>	Date:	<i>07/01/18</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

**Jean-Luc Menard**

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**From:** Marc Bellavance [mbellavance@dartaero.com]  
**Sent:** Thursday, January 18, 2007 11:33 AM  
**To:** Menard, Jean-Luc  
**Subject:** D412-711 VRF Lug  
**Attachments:** D3589-a.pdf; D3589-3\_PRELIMINARY.dxf

JL,

Here is the DXF file for the D3589-3 Lug (Eagle P/N EA20469-22).

**Please take note:**

Material on the drawing is 4130 Steel but Dan need 2 to be made out of **AISI 304 SS**.

Thanks!

Marc

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No virus found in this outgoing message.  
Checked by AVG Free Edition.  
Version: 7.1.410 / Virus Database: 268.16.12/628 - Release Date: 1/15/2007

1/18/2007